

Split

Work Order ID 136635-2

136635

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Thursday, September 03, 2015 8:18:52 AM

Item ID: D4704-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Expandable Pin Assembly

Start Date: 9/1/2015

Start Qty: ~~4.00~~

4

Cust Item ID:

Required Date: 9/1/2015

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: SEP 04 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4704	A								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG USE DT9882, DT9883								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

OCT 01 2015

IX

DAS
36
9-89
15/11/05DAS
38
9-89

NOV 05 2015

Work Order ID 136635***136635***

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Thursday, September 03, 2015 8:18:52 AM

Item ID: D4704-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Expandable Pin Assembly
Start Date: 9/1/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>St 120</u>	0.00							
140									
Packaging	Memo	0.00						<u>MCJ</u>	<u>15-11-06</u>
Packaging									
150	QC21 - Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00						<u>1</u>	<u>MCJ</u>
Quality Control									<u>NOV 06 2015</u>

St 120

20151106

Thursday, September 03, 2015 8:18:58 AM

136635

D4704-041

Required Date: 9/1/2015

Required Qty: 4.00

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4708-1 *D4708-1* Lanyard		Manufactured	No			110	Each	29.0000	1	4			
									**			DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				29					
				126258				29					
D4709-1 *D4709-1* Spring Clip		Manufactured	No			110	Each	8.0000	2	8			
									**			DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				8					
				134344				2		B136461			
				135428				6					
D4711-041 *D4711-041* Expandable Pin Assembly, Modified		Manufactured	No			110	Each	4.0000	2	8			
									**			DAS 36 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				4					
				134477				4		B136633			
MS20613-4C8 *MS20613-4C8* Rivet		Purchased	No			110	Each	222.0000	4	16			
									**			DAS 36 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				222					
				120242				222					

As 20613-4C7

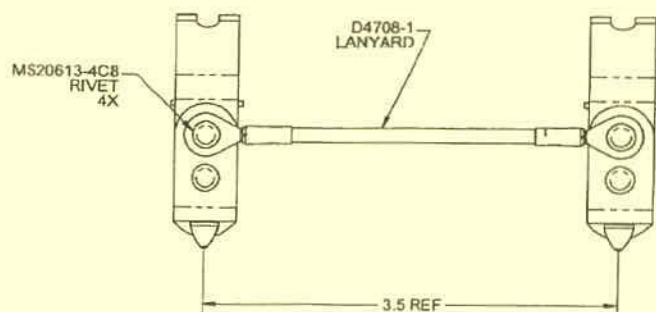
M129036

2x

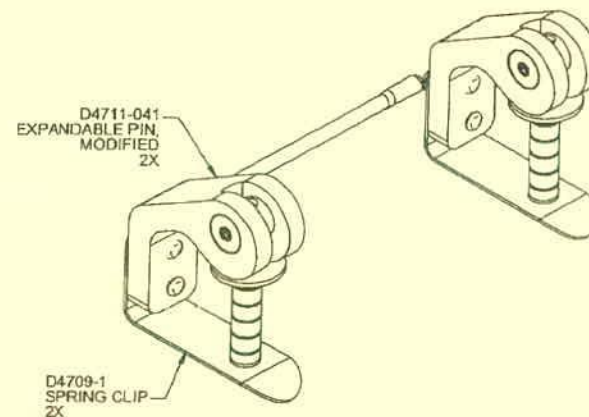
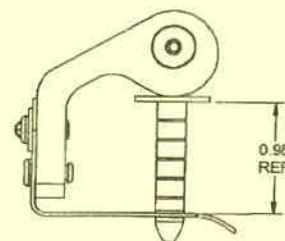
15/11/05

DAS
36
9-89

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4704-041	EXPANDABLE PIN ASSY
1	2	D4711-041	EXPANDABLE PIN, MODIFIED
2	1	D4708-1	LANYARD
3	2	D4709-1	SPRING CLIP
4	4	MS20613-4C8	RIVET



136635 MLO
1809-04



D4704-041 EXPANDABLE PIN ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4704-041" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.39 lbs

2012-10-12

A NEW ISSUE		RP	12.09.19
REV	DESCRIPTION		BY DATE
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D4704	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		EXPANDABLE PIN ASSY	NTS
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